

# Work Order ID 77742

**\*77742\***

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Tuesday, December 20, 2011 12:41:23 PM

Item ID: D350-578-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw  
 Start Date: 12/20/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 1/6/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-12-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								

100 DOCUMENT CONTROL 0.00  
**\*100\***  
 DC Memo 0.00  
 Document Control Photocopy bluefile and create labels per PPP D350-578-011 CHG005 *8/26/20* *JJ for MLJ 12-1-19*

160 Pick Kit 0.00  
**\*160\***  
 Packaging Memo 0.00  
 Packaging *SP 12-01-19.*

170 QC4- 100% Inspect kits for completeness 0.00  
**\*170\***  
 QC Memo 0.00  
 Quality Control *8/26/20* *(Signature)*

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**\*77742\***

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Tuesday, December 20, 2011 12:41:23 PM

Item ID: D350-578-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 12/20/2011 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

**\*180\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: \_\_\_\_\_

*Lev A*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*SP 12-01-20*

*12/1/23*

*12-01-23*

# Picklist Print

Tuesday, December 20, 2011 12:41:31 PM

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Work Order ID: 77742

**\*77742\***

Parent Item: D350-578-011

**\*D350-578-011\***

Parent Item Name: Bearpaw

Start Date: 12/20/2011

Required Date: 1/6/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	----------------	--------------	---------------	----------------	--------

AN4-17A		Purchased	No			160	Each	504.0000	12	96			
---------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

**\*AN4-17A\***

Bolt

\*\*

SP-

Location

Loc Qty

Loc Code

ST359

504

118628

104

118983

300

119798

100

m 112314 6x.  
x m 120187 65x

25x

D2182B		Manufactured	No			160	f	580.1642	2.5	20			
--------	--	--------------	----	--	--	-----	---	----------	-----	----	--	--	--

**\*D2182B\***

Rubber Cushion

\*\*

SP

Location

Loc Qty

Loc Code

ST410

580.16417

66063

53.94817

73932

526.216

20x

Cut qty 6 at 5.00" long

D2274		Manufactured	No			160	Each	1.0000	12	96			
-------	--	--------------	----	--	--	-----	------	--------	----	----	--	--	--

**\*D2274\***

Radius Block

\*\*

B7610430x SP

Location

Loc Qty

Loc Code

ST010

1

73389

1

B77034 60x 12-01-20

D2432		Manufactured	No			160	Each	0.0000	2	16			
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**\*D2432\***

206 (24") Bearpaw

\*\*

78324

# Picklist Print

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Tuesday, December 20, 2011 12:41:31 PM

Work Order ID: 77742

**\*77742\***

Parent Item: D350-578-011

**\*D350-578-011\***

Parent Item Name: Bearpaw

Start Date: 12/20/2011

Required Date: 1/6/2012

Start Qty: 8.00

Required Qty: 8.00

D2438 Manufactured No 160 Each 131.0000 6 48

**\*D2438\***

Clamp

\*\*

SP. 12-01-20

Location

Loc Qty

Loc Code

ST456

131

69737

84

73400

47

48x

D2529 Manufactured No 160 Each 238.0000 12 96

**\*D2529\***

Washer

\*\*

SP. 12-01-20

Location

Loc Qty

Loc Code

ST016

238

71161

6

76086

232

96x

MS21042L4 Purchased No 160 Each 9,233.000 12 96

**\*MS21042L4\***

Nut

\*\*

SP 12-01-19.

Location

Loc Qty

Loc Code

ST300

9233

117441

51

117601

342

118451

133

119017

3707

119075

5000

96x

# Picklist Print

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**\*77742\***

Parent Item: D350-578-011

**\*D350-578-011\***

Parent Item Name: Bearpaw

Start Date: 12/20/2011

Required Date: 1/6/2012

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

8,902.000

24

192

**\*NAS1149D0463.J\***

Washer

**\*\***

*SP12-01-19*

Location

Loc Qty

Loc Code

ST298

8902

116025

16

116805

0

117291

1

117460

2

118179

42

118384

194

118612

3

119042

11

119075

8464

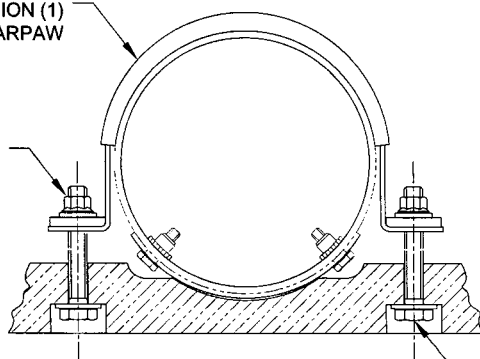
119097

169

*192 x*

D2438 CLAMP (1)  
D2182B050 RUBBER CUSHION (1)  
3 PL PER BEARPAW

MS21042L4 NUT (1)  
AN960JD416 WASHER (1)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-17A BOLT (1)  
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A  
Figure 4 – Clamping Detail

## 5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F

Date: 08.08.28